

5/20

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23040
<b>Description:</b> Inside Washer	<b>Part Number:</b>	D3233-1
<b>Dwg:</b> D3233 Rev. B <b>PAGE 2</b> 05.06.14	<b>Qty:</b>	22 23
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.13	20
2	MC	Turn as per Folio FA517 and Dwg D3233 Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall (M1020TR2.000W.500) Identify for D3233-1 Batch: M17015	JG	05/07/04	23
3	QC2	Inspect parts as they come off the machine Identify as D3233-1	JG	05/07/04	23
4	QC8	Second check	FE	05.07.04	23
5	MC	Deburr	JG	05/07/04	23
6	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	ML	05.08.11	23
7	QC3	Inspect Powder Coat	2	05.08.15	23
8	QC5	Inspect work to Step 5	2	05.08.15	23
9	ST	Identify and Stock	CPL	05.08.15	23
10	AC	Cost / part: 3.5c	JGR	05.08.17	23
11	DC	Close W/O 3.13 Inspect Level 21	Q	05/08/17	23

Rev	Date	Change	Revised By	Approved
A	05.03.11	New issue	KJ/JLM	
B	05.03.31	Added Powder Coat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		- Update dwg with change. (see attached dwg for detail)					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

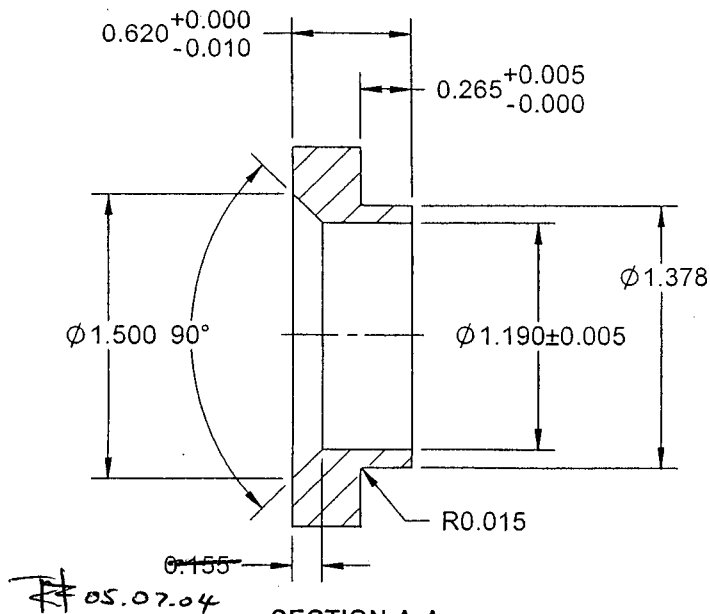
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/08/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

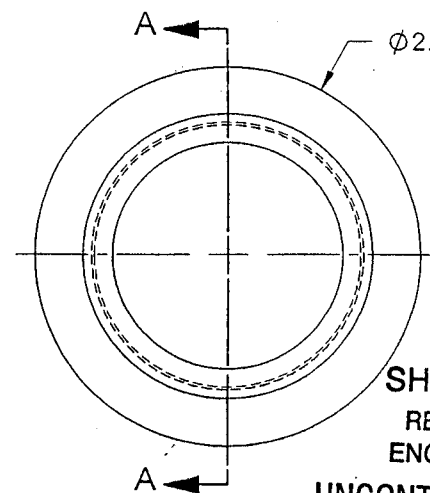


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



**SECTION A-A**

**D3233-1 INSIDE WASHER**

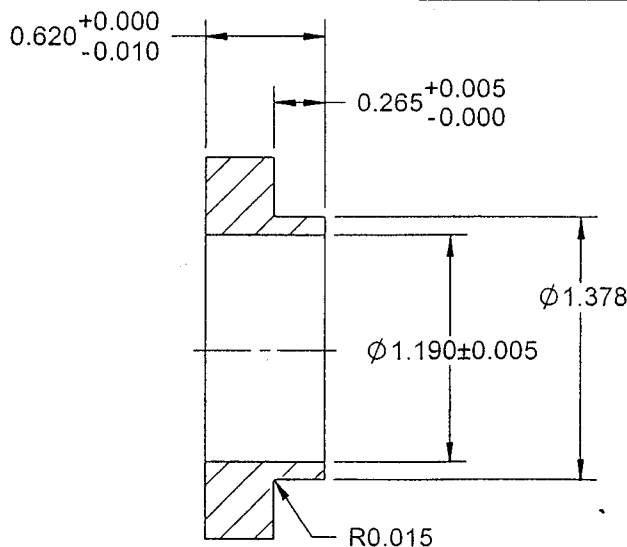


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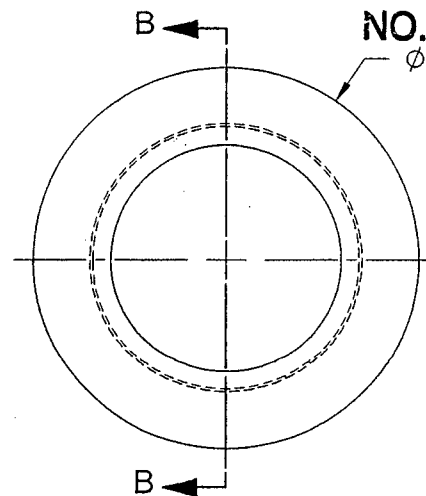
WORK ORDER

NO. 23040  
Ø2.00



**SECTION B-B**

**D3233-3 OUTSIDE WASHER**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2005  
02:25 pm

Work Order No : 0023040  
Project Name : D3233-1  
Project For : WK520  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3233-1  
Description : Inside Washer  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 04-12-05  
Est Finish Date : 05-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD	Work Order:	23040
Description:	Part Number:	D3233-1
Inspection Dwg: D3233 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

[illegible]

Measured by: S.G.	Audited by: G	Prototype Approval: N/A
Date: 05/07/04	Date: 05.07.04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	